

2018

[Dart Hawkesbury] Job Sheet - David, Logan

W-T-F

4306



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM632V3023125-1
Job Sheet 181067



DAS
21
9-89

8-21

Part No: RBEM632V3023125-1

Job Qty: 8 ea

Part Name: Back Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/20/18

Job Tracking No:

Due Date: 7/30/18

Created By: Logan David

Type: SOLD

Description:

Note: RBEM632V3023125 rev.1 IPP REV:A 18.07.18 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		7/30/18	0.00	0.00	Start Up Waterjet2		DL 18/07/25
105	Waterjet	6 pcs		7/30/18	0.00	1.00	Waterjet 2 OMAX		DL 18/07/25
108	QC	6 pcs		7/30/18	0.00	0.00	QC2 Waterjet-4		DL 18/07/25
110	Mill Conv	6 pcs		7/30/18	0.50	1.50	Mill Conv 2		DL 18/7/30
120	QC	6 pcs		7/30/18	0.00	0.00	QC2 Machining-5		DL 18/07/13
130	QC	6 pcs		7/30/18	0.00	0.00	QC8 Machining-5		DL 18/07/13
140	HandFinish	6 pcs		7/30/18	0.00	0.75	HandFinish7		DL 18/07/13
150	Powdercoat	6 pcs		7/30/18	0.00	0.75	Powdercoat13		DL 18/07/13
160	QC	6 pcs		7/30/18	0.00	0.00	QC3		DL 18/07/13
170	Packaging	6 pcs		7/30/18	0.00	0.00	Packaging3-2		DL 18/07/13
180	QC21-SA	6 Ea		7/30/18	0.00	0.00	QC21		DL 18/07/13

Part Op 105 - ***EUROCOPTER FOLDER*** 1-Cut as per Dwg Dwg Rev: / Prog Rev: / 2-Deburr if necessary
 Descriptions: 110 - 1- CHAMFER, DRILL HOLES AND TAP HOLES 3- DEBURR
 150 - ***MASK THREADED HOLES PRIOR TO POWDERCOAT*** START TIME: 9:10pm OVEN TEMPERATURE:
 320°F FINISH TIME: 9:40pm
 170 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.500	Hot Rolled Steel Plate 0.500" (44W)	.3780 sf (.063 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-HRS-P-0.500	0	14	0

Part Specifications

Specifications could not be found.

Plex 7/20/18 8:07 AM dart.logan.david

DAS
13
9-89



Container No: S096039



Part: RBEM632V3023125-1

Job No: 181067

Serial No/Batch: S096039

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 613 632-6200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 07/25/18

BAG

88

88

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

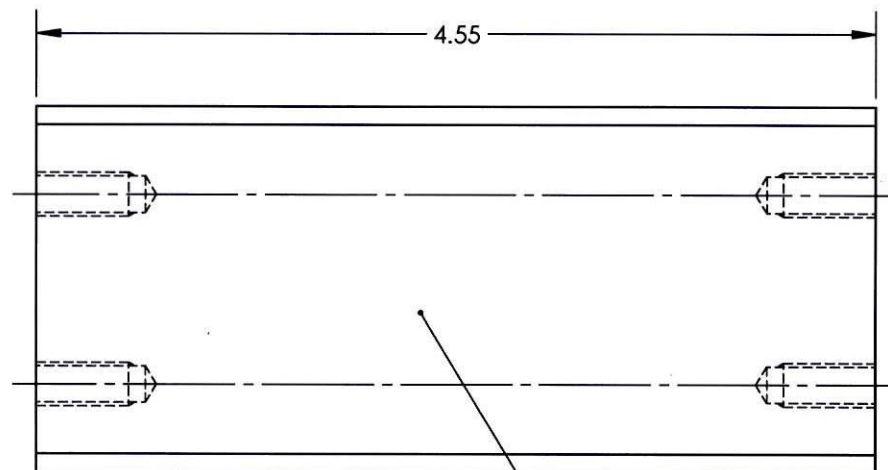
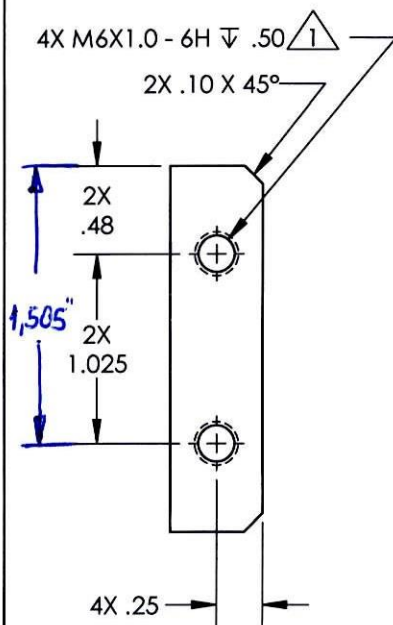
QA Closed: _____ Date: _____

Work Order update only ☐

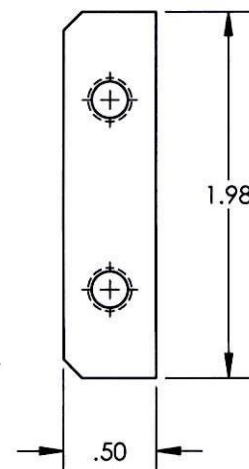
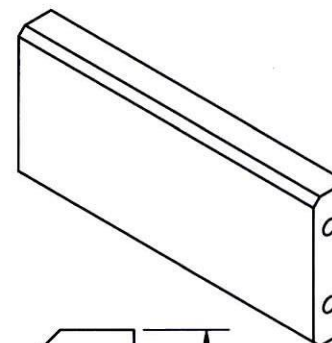
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



INK STAMP T/N, S/N,
"MADE IN USA"



NOTE:

1 NO POWDERCOAT THIS SURFACE.

SHOP COPY
RETURN TO
ENGINEER
UNCONTROLLED COPY
SUBJECT TO REVISION
WITHOUT NOTICE
WORK ORDER
NO. 181067
20180720

BACK PLATE

DART AEROSPACE	
TITLE UPPER SERVO CONTROL AXLE EXCHANGE	
DWG NO. RBEM632V3023125-1	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .005 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .01 ANGLES ± .0°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125/
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL H175
SCALE 1:1	DATE 3/24/2016 SHEET 2 OF 6

815-1000/700-900